

**Work Order ID 70825**

Wednesday, June 15, 2011 2:29:29 PM

Page 1

Item ID: D412-630-034

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli Access Step RH Folding

Start Date: 6/15/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 6-06-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile &amp; create labels per PPP D412-630-034 CHG003

Signature: [Signature]  
CL 11-6-17

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M107929

COAT exposed HARDWARE WITH LPS PROCYON

A/R LPS PROCYON BATCH: M114596

Signature: [Signature]  
11/06/17 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Required Date: 6/22/2011 Req'd Qty: 2.00



Customer:

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Run Start



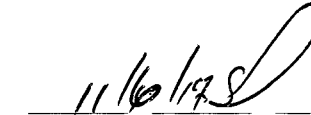
Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
		8 w/06/17							
130  Packaging Packaging	Pick Kit  Memo	0.00 0.00							
140  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00							
		8 w/06/17							



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Stop



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Start Date: 6/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-034 Location: _____ PPP Rev: <u>  A  </u>								
160 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

6/15/11 (2)

11/6/2011

11-06-20 (2)

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# Picklist Print

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Page 1  
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Work Order ID: 70825



Parent Item: D412-630-034



Parent Item Name: Heli Access Step RH Folding

Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-11-08 JLM  
IPP rev B ecn1019, added D2807-041 EC verified by:DD  
IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310C8  Nut		Purchased	No			110	Each	31.0000	2	4			
<div> <div>Location</div> <div>ST324</div> <div>111819</div> <div>117771</div> </div> <div> <div>Loc Qty</div> <div>31</div> <div>1</div> <div>30</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
AN3C21A  BOLT		Purchased	No			110	Each	85.0000	2	4			
<div> <div>Location</div> <div>ST352</div> <div>109148</div> <div>117366</div> <div>117514</div> </div> <div> <div>Loc Qty</div> <div>85</div> <div>15</div> <div>20</div> <div>50</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													
AN8C16  Bolt		Purchased	No			110	Each	45.0000	2	4			
<div> <div>Location</div> <div>ST345</div> <div>106066</div> </div> <div> <div>Loc Qty</div> <div>45</div> <div>45</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

EP511/06/17

13

EP511/06/17

4

EP511/06/17

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00



Manufactured No

110 Each

21.0000

1

2

Location

Loc Qty

Loc Code

WA005

21

66811

21



Manufactured No

110 Each

3.0000

1

2

Location

Loc Qty

Loc Code

ST149

3

64093

3



Manufactured No

110 Each

1.0000

1

2

Location

Loc Qty

Loc Code

ST150

1

66643

1



Manufactured No

110 Each

25.0000

2

4

Location

Loc Qty

Loc Code

ST022

25

60540

2

66336

3

69671

20

*EP 11/06/17*

*2*  
*EP 11/06/17*

*2*  
*EP 11/06/17*

B69400 (12)

*1*  
*EP 11/06/17*

*3*  
*1*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Heli Access Step RH Folding

Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00

D2813  
Washer

Manufactured No 110 Each 26.0000 2 4

Location	Loc Qty	Loc Code
ST023	26	
61051	5	
69386	21	

*Ep 5/11/06/17*

D3395-1  
Bushing

Manufactured No 110 Each 36.0000 4 8

Location	Loc Qty	Loc Code
ST052	36	
68491	6	
69387	30	

*Ep 5/11/06/17*

*8* D3562-042  
Step Assembly, RH  
MS21043-3  
Nut

Manufactured No 110 Each 0.0000 1 2

*B69399* *(20)*

*Ep 5/11/06/17*

Purchased No 110 Each 283.0000 4 8

Location	Loc Qty	Loc Code
FG	72	
103691	72	
ST301	211	
112314	211	

*Ep 5/11/06/17*

MS24665-302  
Cotter Pin

Purchased No 110 Each 192.0000 2 4

Location	Loc Qty	Loc Code
ST357	192	
117460	192	

*Ep 5/11/06/17*

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Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 70825

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00

MS24693-C280

Purchased

No

110

Each

19.0000

2

4



Screw

Location

Loc Qty

Loc Code

ST310

18

115594

18

ST318

1

111279

1

NAS1515H3

Purchased

No

110

Each

132.0000

6

12



Washer

Location

Loc Qty

Loc Code

ST277

132

116373

32

117460

100

NAS1515H5L

Purchased

No

110

Each

84.0000

4

8



WASHER

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

44

111359

44

NAS1515H8

Purchased

No

110

Each

243.0000

4

8



Washer

Location

Loc Qty

Loc Code

ST278

243

111275

43

111411

200

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Page 4

W/O:		WORK ORDER CHANGES					
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Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00

AN44C7A

Purchased

No

130

Each

73.0000

1



Eyebolt

Location

Loc Qty

Loc Code

ST362

73

109013

33

111308

40

AN4C10A

Purchased

No

130

Each

81.0000

1



Bolt

Location

Loc Qty

Loc Code

ST356

81

111295

4

112243

47

114523

30

AN4C15A

Purchased

No

130

Each

125.0000

2



Bolt

Location

Loc Qty

Loc Code

ST358

125

115835

25

115936

2

117441

48

117795

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, June 15, 2011 2:29:37 PM

Page 6

Work Order ID: 70825

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00

AN4C6A \*

Purchased

No

130

Each

330.0000

1



Bolt



SD

Location

Loc Qty

Loc Code

FG

4

103344

4

ST306

50

117313

50

ST356

276

116704

1

117619

150

117794

50

117872

75

AN5C15A

Purchased

No

130

Each

73.0000

2



Bolt



SD

Location

Loc Qty

Loc Code

ST339

73

111819

23

117764

25

117885

25

D2806-1

Manufactured

No

130

Each

22.0000

2



Bushing



4 11/6/17 SD (20)

Location

Loc Qty

Loc Code

ST022

22

64074

2

68492

20

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W/O:		WORK ORDER CHANGES					
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# Pieclist Print

Wednesday, June 15, 2011 2:29:37 PM

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Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00

D2806-3

Manufactured No

130 Each

23.0000

2

4



Bushing



11/6/17 SD

Location

Loc Qty

Loc Code

ST022

23

64075

3

69401

20

D2810-5

Manufactured No

130 Each

16.0000

1



Strut



SD

Location

Loc Qty

Loc Code

ST265

16

52034

1

68493

5

69402

10

D3396-1

Manufactured No

130 Each

24.0000

2

4



Spacer



11/6/17 SD

Location

Loc Qty

Loc Code

ST052

24

46748

24

4

W/O:		WORK ORDER CHANGES					
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Wednesday, June 15, 2011 2:29:38 PM

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Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00

MS21043-4

Purchased

No

130

Each

1,147.000

4

8



Nut



116170

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

107

117423

107

ST301

1000

117601

500

117793

500

MS21043-5

Purchased

No

130

Each

511.0000

3



Nut



116170

Location

Loc Qty

Loc Code

FG

20

101418

20

ST301

491

112314

391

116548

100

NAS1515H4

Purchased

No

130

Each

188.0000

7

14



Washer



116170

Location

Loc Qty

Loc Code

ST277

188

111525

2

116169

36

117460

50

117735

100

74

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Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1515H5

Purchased

No

130

Each

123.0000

7

14



Washer



11/6/11

SL

2

Location

Loc Qty

Loc Code

FG

40

103286

20

103691

20

ST277

83

109430

83

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

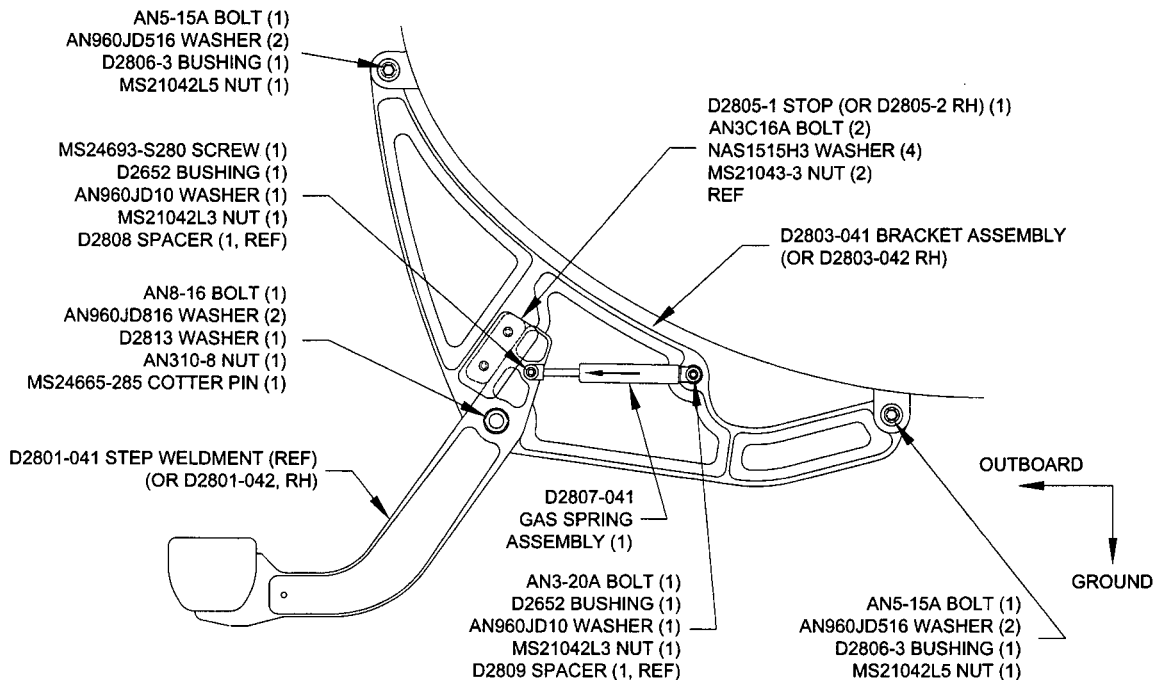
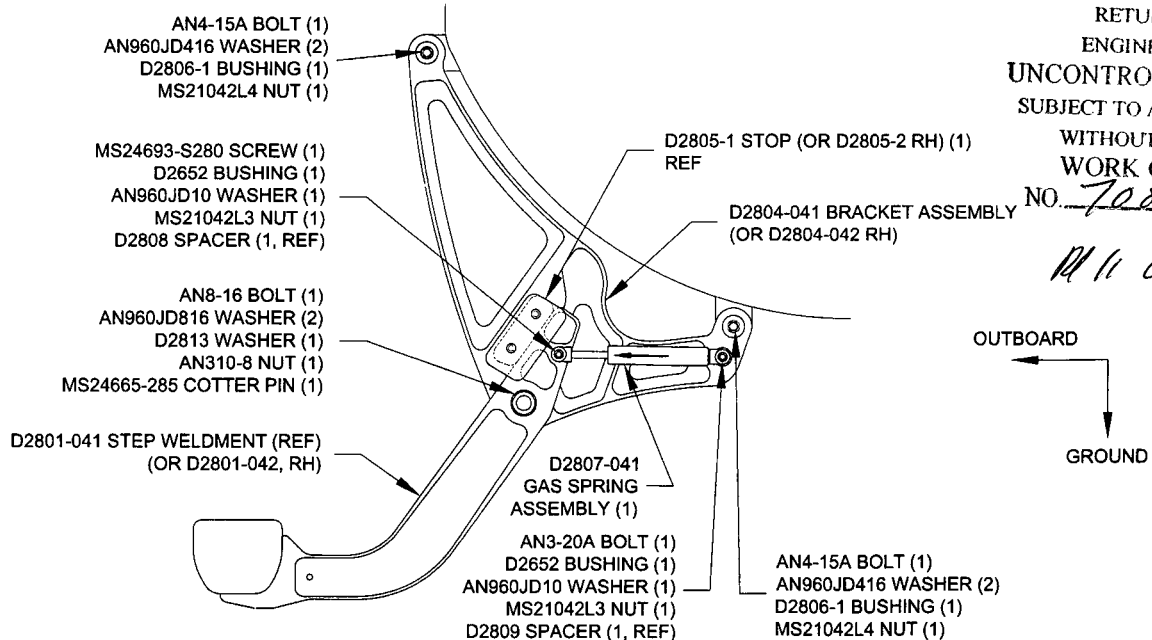
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**D412-630-013/-014 Heli-Access-Step™ Installation****FIGURE 8 – STA 84.29 for D412-630-013/-014 Heli-Access-Step™ Installation**  
(View rotated 90° CW)**FIGURE 9 – STA 155.06 for D412-630-013/-014 Heli-Access-Step™ Installation**  
(View rotated 90° CW)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 70825

11/11/06-15

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Revision: M  
Date: 08.12.12

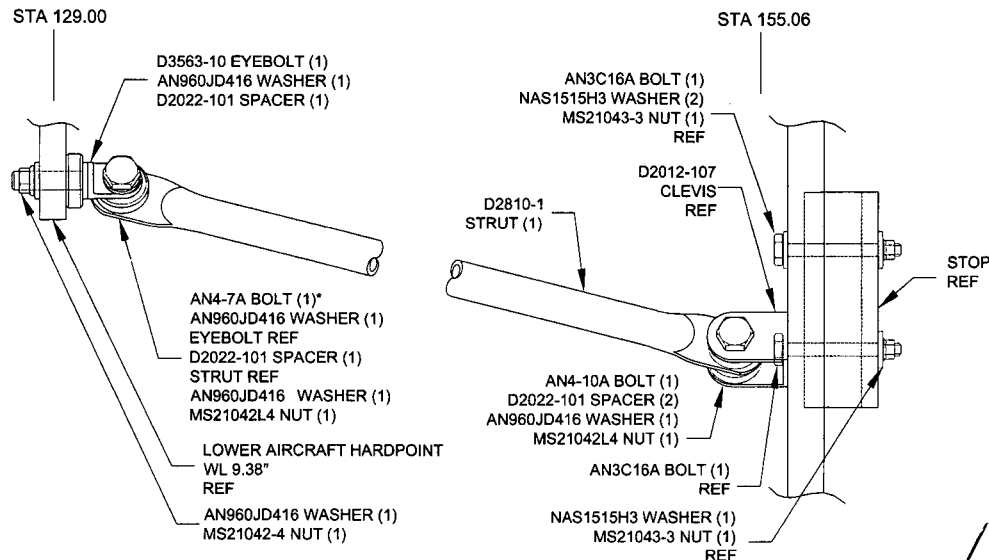
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



\* IF ADJUSTMENT OF THE STRUT IS REQUIRED TO AVOID OTHER HARDWARE ON THE AIRCRAFT, IT IS ACCEPTABLE TO USE LONGER AN4 BOLTS AND ADDITIONAL WASHERS AS REQUIRED TO ADJUST THE ATTACHMENT OF THE D2810-1 STRUT TO THE EYEBOLT.

**FIGURE 10 – Strut Detail for D412-630-013/-014 Heli-Access-Step™ Installation (NOT TO SCALE)**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

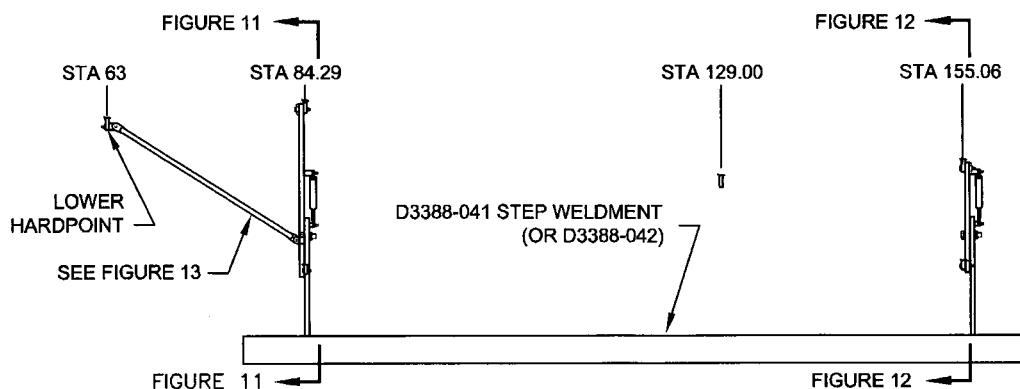
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

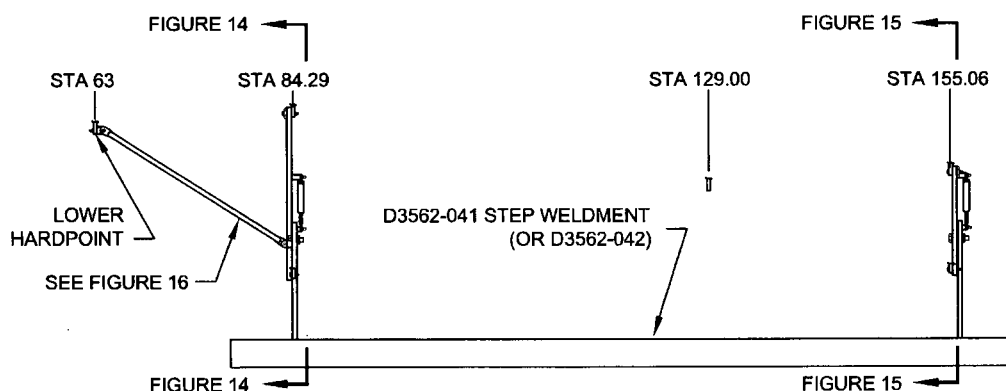
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

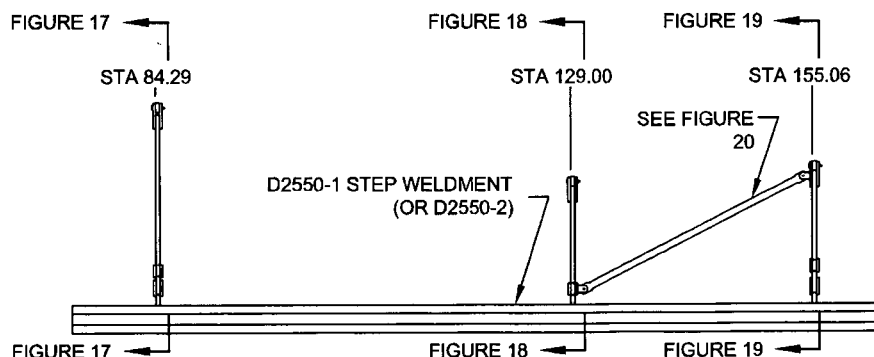
**D412-630-023 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)**  
**D412-630-024 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)**



**D412-630-033 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)**  
**D412-630-034 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)**



**D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)**  
**D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)**



**FIGURE 3 – D412-630 Heli-Access-Step™ Installations**

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Revision: **M**  
 Date: 08.12.12

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)